

# Work Order ID 81760

Friday, March 16, 2012 3:37:13 PM

**\*81760\***

Page 1

Item ID: D3913-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Base Assembly, 350  
 Start Date: 3/20/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *mf* Date: *12-03-16* Tooling: Date:  
 QC: Date: SPC (Y/N): Date:  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *118366* 0.00  
**\*100\*** Large Fab  
 Memo 0.00  
 1- assemble ribs, weld as per dwg D3913 using DT9610A  
 \*\*\*inspect before welding mesh\*\*\*  
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends  
 3- weld hinge (3) and Mounting brackets as per dwg D3913  
 \*\*\*take lid to locate hinge and bracket\*\*\*  
*1x* *Ø* *PL 12-04-13*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\*** QC  
 Memo 0.00  
 Quality Control  
*1* *Ø* *BF 12-04-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 81760**

Friday, March 16, 2012 3:37:13 PM

**\*81760\***

Page 2

Item ID: D3913-041

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop **\*NS2\***

Start Date: 3/20/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

1  $\phi$  12-4-10

# Dart Aerospace Ltd

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\*81760\*

Friday, March 16, 2012 3:37:13 PM

Page 3

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 Required Date: 3/30/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat  1ST COAT: 12:50 START TIME: 4:00F OVEN TEMPERATURE: 400F FINISH TIME: 1:20 ***** 2nd coat if necessary ***** 2ND COAT: 1:30 START TIME: 4:00F OVEN TEMPERATURE: 400F FINISH TIME: 2:00	0.00  0.00				1X			M-L 12/04/16
140 *140* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				(K)			CP 12/04/17

M121134

# Dart Aerospace Ltd

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Friday, March 16, 2012 3:37:13 PM

**\*81760\***

Page 4

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Revision ID:

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Start Date: 3/20/2012 Start Qty: 1.00

**\*1\***

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Required Date: 3/30/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

SP 12-04-16.

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

8/2/2012

170

Identify as per dwg &amp; Stock Location

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

GA  
w/o  
81755

(ix)

EP 12/04/17

**Dart Aerospace Ltd**

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Page 5

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Reference:

Approvals:    Process Plan:    Date:    Tooling:    Date:    Run    Start    **\*NR1\***  
                 QC:    Date:    SPC (Y/N):    Date:    Stop    **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/4/17  
mc  
12-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, March 16, 2012 3:37:13 PM

Page 1

Work Order ID: 81760

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	2		SAD 12-01-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				69739		1							
				70766		2							
				77045		1							
				77523		19							
D3913-1 Rib		Manufactured	No			100	Each	1.0000	1	1		SAD 12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		1							
				78039		1							
D3913-15 Wide Handle Plate		Manufactured	No			100	Each	11.0000	1	1		SAD 12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		11							
				78321		1							
				80778		10							
D3913-3 Rib		Manufactured	No			100	Each	5.0000	1	1		SAD 12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		5							
				69160		1							
				78287		4							
D3913-7 Rib		Manufactured	No			100	Each	6.0000	2	2		SAD 12-04-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				79416		6							

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, March 16, 2012 3:37:13 PM

Page 2

Work Order ID: 81760

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-9	Manufactured	No	100	Each	2.0000	1	
Hinge Rib							SAD 12-04-11
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		WA006	2				
		70138	1				
		79876	1		B81200	①	
D3916-041	Manufactured	No	100	Each	8.0000	2	
Rib Assembly							SAD 12-04-11
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		WA006	8				
		69161	2				
		79909	6		B80824	2	
D3916-5	Manufactured	No	100	Each	8.0000	3	
Light Rib							SAD 12-04-11
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		WA006	8				
		79908	8		B81434	①	
D4016-1	Manufactured	No	100	Each	23.0000	3	
Hinge Half, Base					B81190	2	
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		WA005	23				
		75281	4				
		79413	19		B81702	3	
D4017-7	Manufactured	No	100	Each	2.0000	1	
Rib							SAD 12-04-11
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
		WA005	2				
		69730	1				
		74682	1		81176	①	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, March 16, 2012 3:37:13 PM

Page 3

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-9  
Rib

Manufactured No

100 Each 8.0000

2 <sup>2</sup> SAD 12-04-11

Location

Loc Qty

Loc Code

WA  
79415  
WA006  
70341  
73531

2  
2  
6  
2  
4

B81445  
B81515

②  
①

D4020-11  
End Mesh, Basket

Manufactured No

100 Each 10.0000

2 2 PL 12-04-13  
B81370 → ⑤

Location

Loc Qty

Loc Code

WA035  
69648  
78693

10  
2  
8

D4021-1  
Handle Plate

Manufactured No

100 Each 48.0000

3 SAD 12-04-11

Location

Loc Qty

Loc Code

WA  
69518  
74316  
74946  
79414  
WA005  
80826  
81433

8  
0  
0  
0  
8  
40  
22  
18

③

D4034-041  
Aft Upper Rib Assembly

Manufactured No

100 Each 5.0000

1 SAD 12-04-11

Location

Loc Qty

Loc Code

WA006  
81172

5  
5

B81171

①

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Friday, March 16, 2012 3:37:13 PM

Page 4

Work Order ID: 81760

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No

100 Each 3.0000

1 *\$100 12-04-11*

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

3

78036

1

78329

2

*B81173*

*33*

M304EX0.75-16F

Purchased No

100 sf 693.0022

33 33

Expanded Metal Flat SS

*12-04-12*

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

693.0020757

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

39.8113116

120917

276.99263

33

AN3-10A

Purchased No

150 Each 379.0000

6 6

Bolt

*SP*

Location

Loc Qty

Loc Code

GA

75

119084

75

ST351

304

117795

4

120873

300

*lex*

AN960JD8

NAS1149DN832J

Purchased No

150 Each 0.0000

*2 m120922 12-04-16*

Washer

Friday, March 16, 2012 3:37:13 PM

Shop Packet Print

Page 4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 5

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Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 150 Each 496.0000 2 SP

Bumper

Location Loc Qty Loc Code

ST504 496

46064 496

D4021-5

Manufactured No

150 Each 7.0000

2 2x  
B31183 SP

Blanking Plate

Location Loc Qty Loc Code

GA 7

73478 7

MS20600-AD4W3

Purchased No

150 Each 1,304.0000

2 SP 2

Cherry Rivets

Location Loc Qty Loc Code

ST321 1171

111636 36

117505 6

117601 27

118626 602

120308 500

WA018 133

107939 133

MS21042L3

Purchased No

150 Each 3,041.0000

6 SP 12-04-16.

Nut

Location Loc Qty Loc Code

ST300 3041

117441 16

117885 32

118451 5

118927 3

119017 2812

119075 173

6x

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Friday, March 16, 2012 3:37:13 PM

Page 6

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Start Date: 3/20/2012

Required Date: 3/30/2012

Parent Item Name: Long Basket Base Assembly, 350

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

654.0000

12

12

WASHER

80 12-04-16.

Location

Loc Qty

Loc Code

ST275

654

117735

37

119225

14

120498

200

120910

200

120986

200

17317

3

121

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

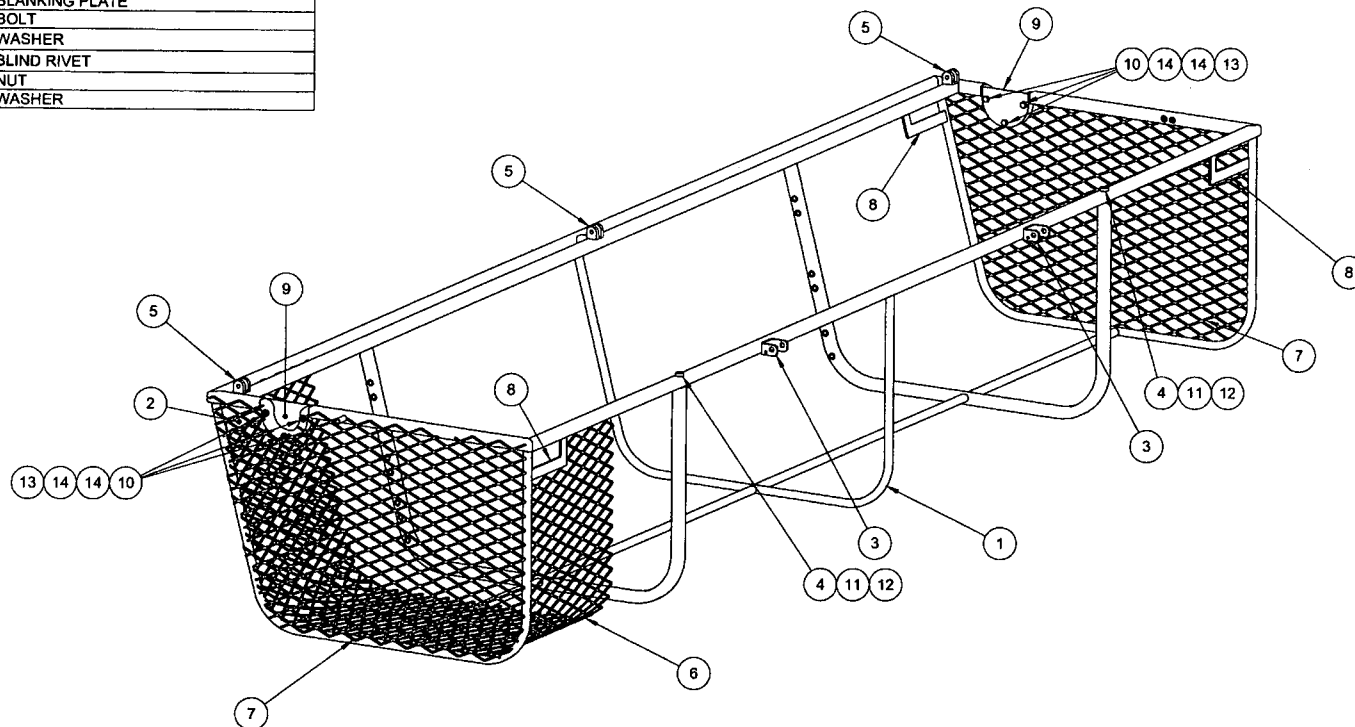
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

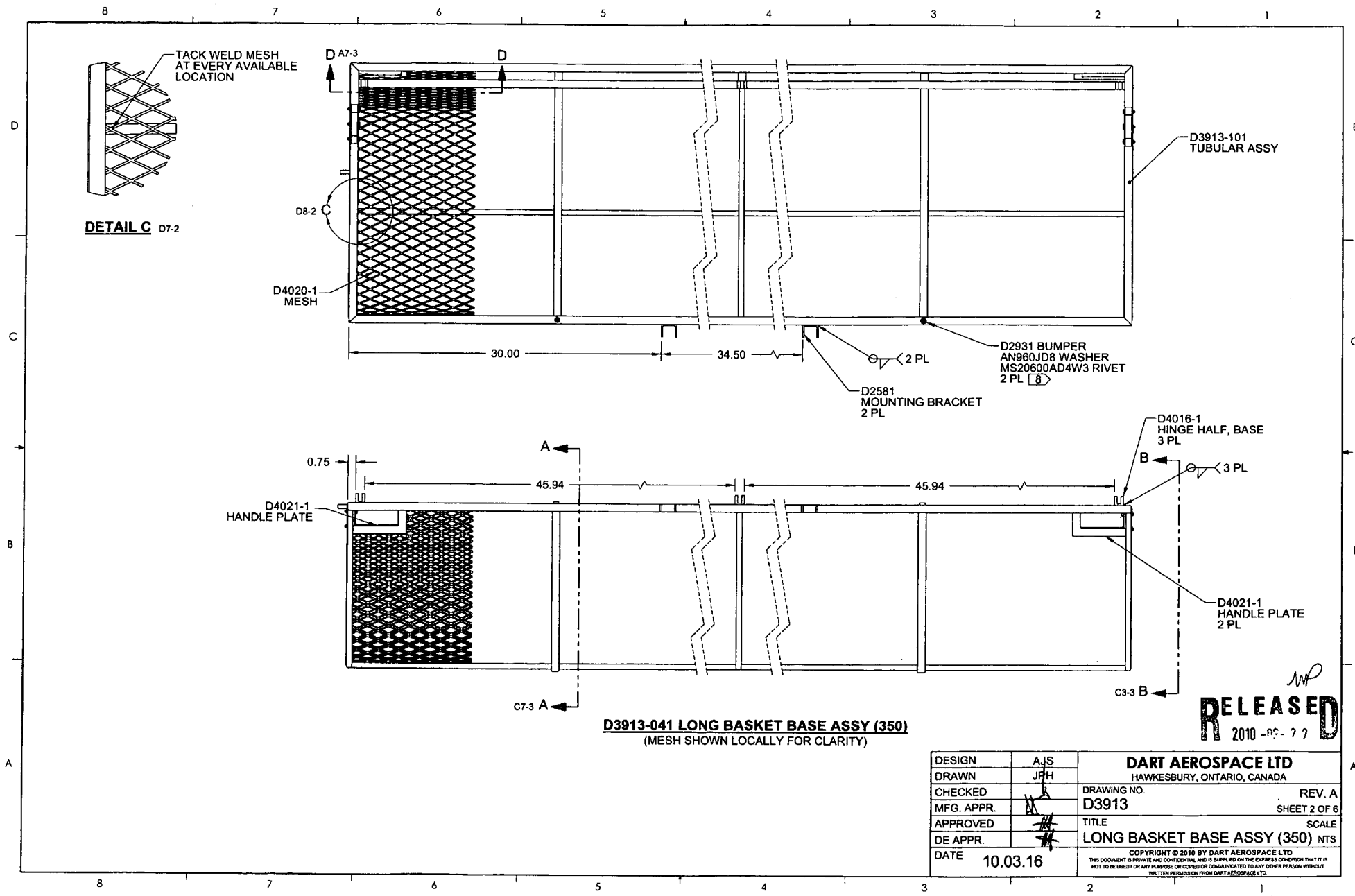
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
JW

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3913</b>	REV. A SHEET 1 OF 6
TITLE <b>LONG BASKET BASE ASSY (350) NTS</b>	
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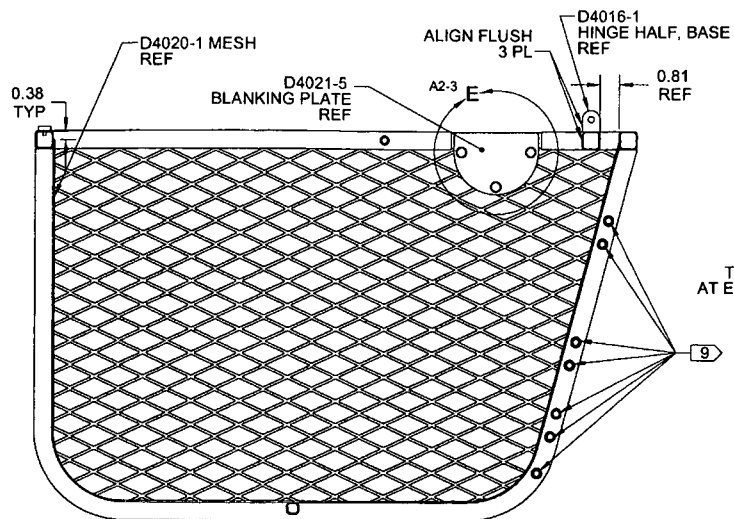


**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

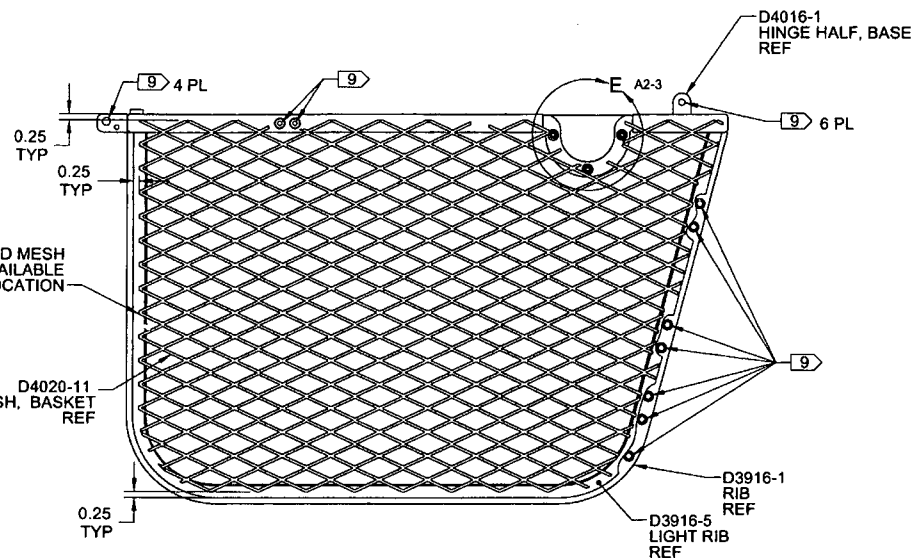
**RELEASED**  
2010 - 07 - 27

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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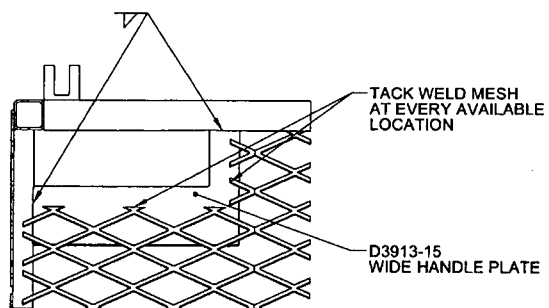




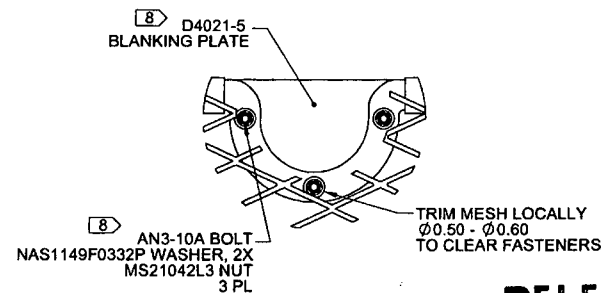
**SECTION A-A** A5-2







**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

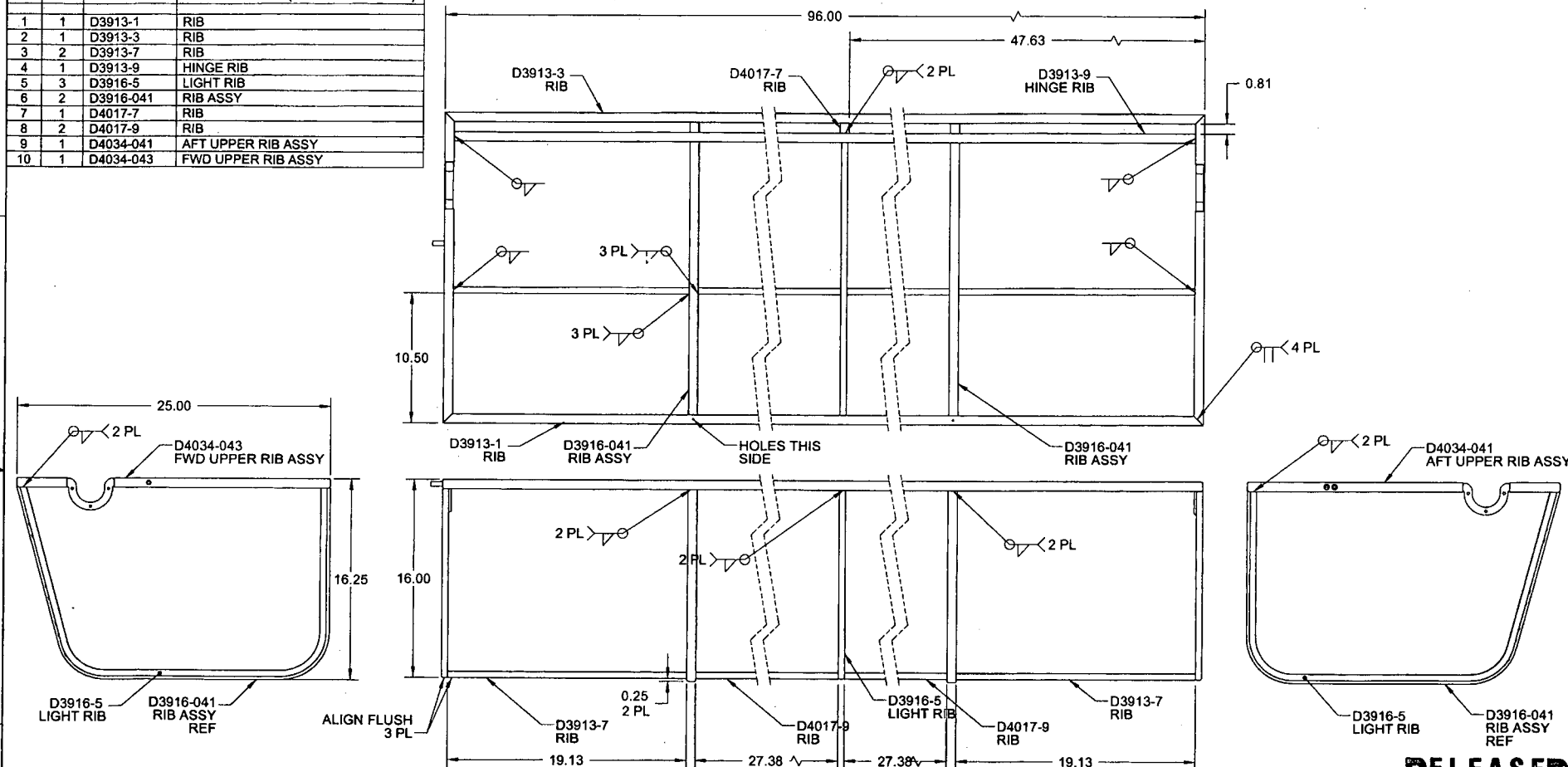


**DETAIL E** D2-3  
D6-3

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



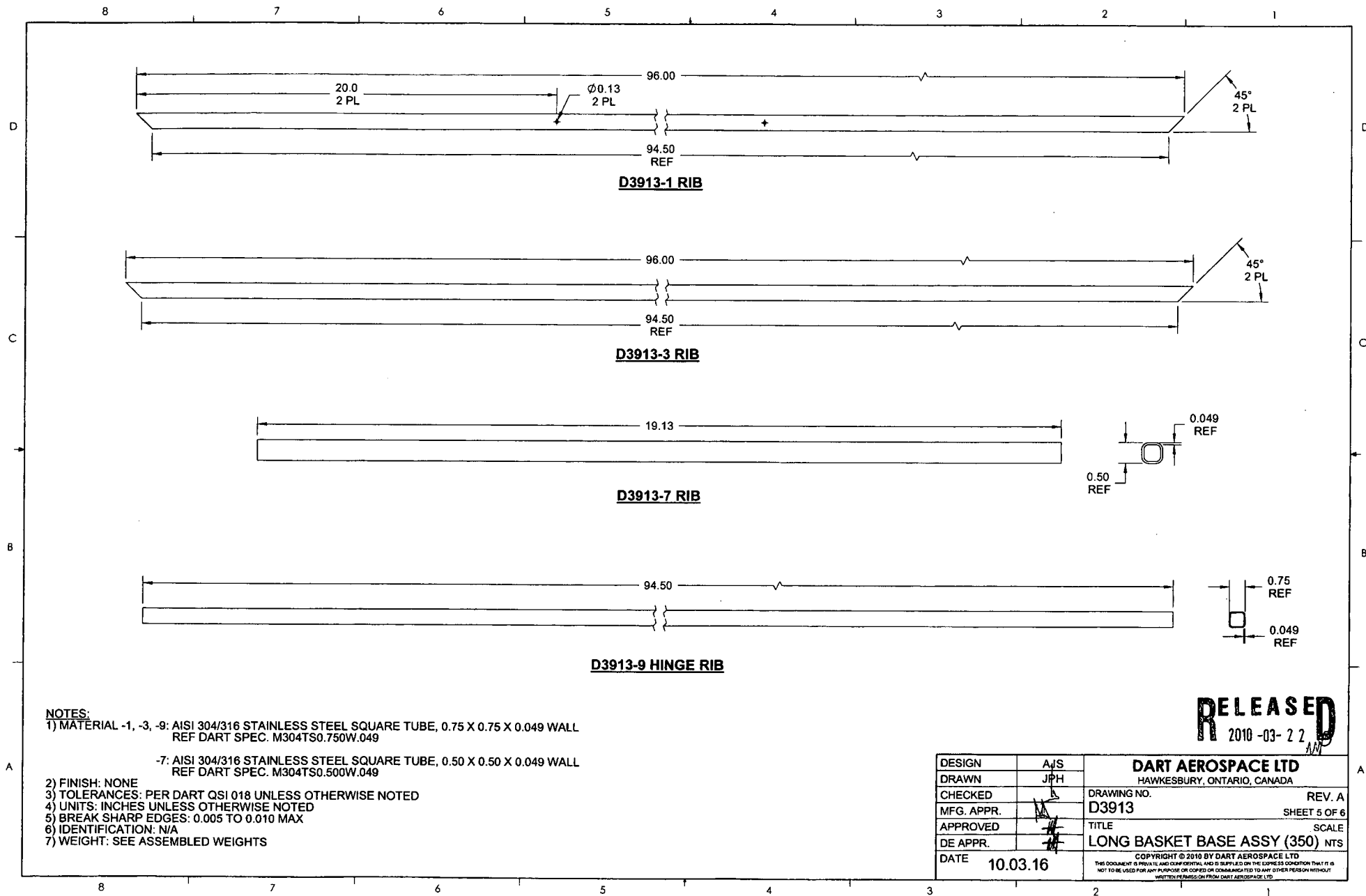
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

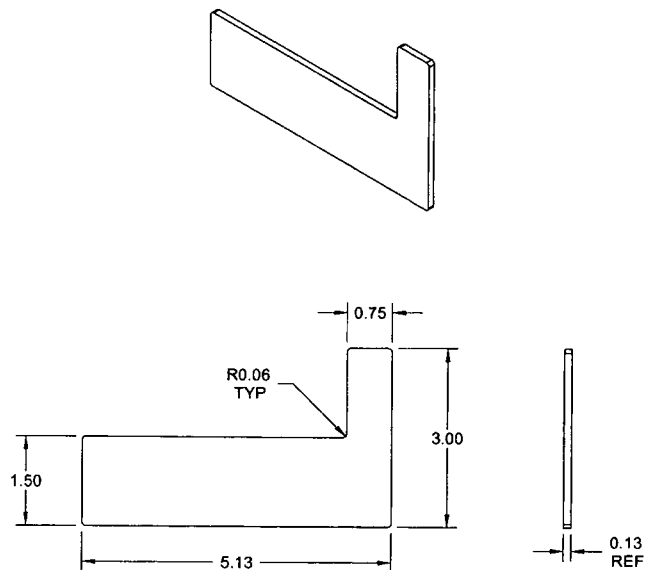
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22





**D3913-15 WIDE HANDLE PLATE**

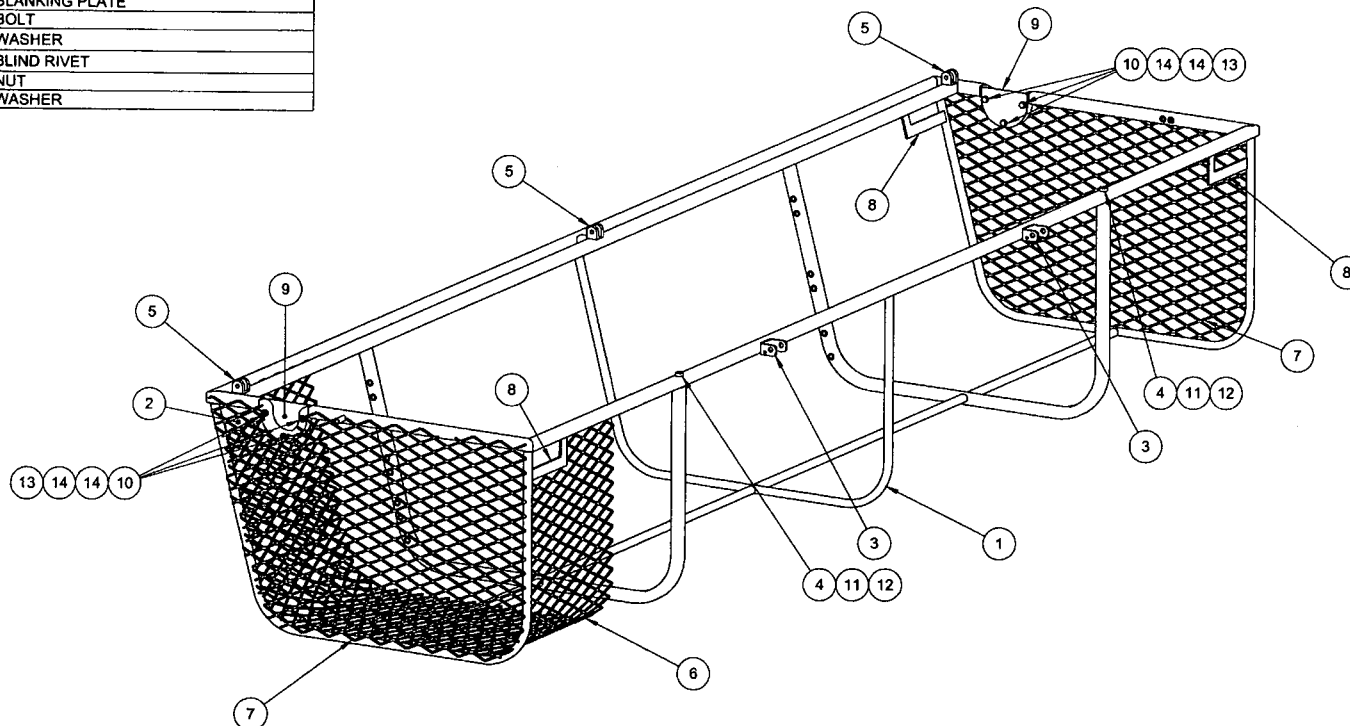
**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. <b>D3913</b>	REV. A
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350) NTS</b>	
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
JPH

A NEW ISSUE		JPH	10.03.16
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<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3913</b>	REV. A SHEET 1 OF 6
TITLE <b>LONG BASKET BASE ASSY (350) NTS</b>	
SCALE	
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